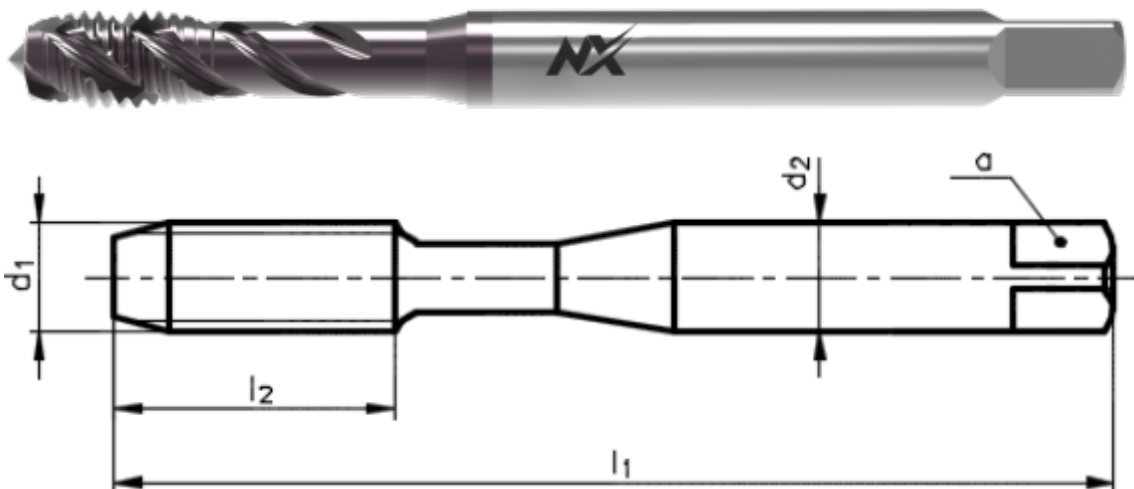


Machine tap with spiral flute 40°

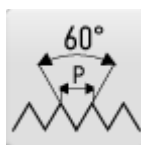


CATALOGUE NUMBER: 2280NX

High performance machine tap with spiral flutes, metric, DIN 371, TiCN coated, suitable for case hardened and nitriding steels, stainless steels with strength up to 1000 N/mm², spheroidal and malleable cast iron, aluminium alloys, copper and zinc alloys.



THREAD M
ISO Metric coarse thread



PROFILE SKETCH
60°



THREAD STANDARD
DIN13



TYPE VA
Tap for stainless steels



TAP MATERIAL
Vanadium extra high speed steel HSSE V3



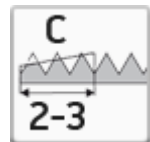
COATING
Titanium carbonitridenitride coating



TAP STANDARD
DIN 371



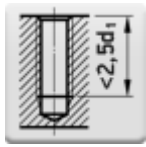
THREAD TOLERANCE
ISO 2 - 6H



CHAMFER C
Length 2-3 pitch



SPIRAL FLUTE ANGLE
40°



HOLE TYPE

Blind hole (thread length $< 2,5 d_1$)

Select product model

ID	D1	P	Tolerance	I1	I2	d2	a	Price excl. VAT	Price incl. VAT
042038132030000	M3	0,5	6H	56	5	3,5	2,7	30.15 EUR	36.48 EUR
042038132040000	M4	0,7	6H	63	7	4,5	3,4	29.50 EUR	35.70 EUR
042038132050000	M5	0,8	6H	70	8	6	4,9	30.45 EUR	36.84 EUR
042038132060000	M6	1	6H	80	10	6	4,9	31.35 EUR	37.93 EUR
042038132080000	M8	1,25	6H	90	13	8	6,2	44.70 EUR	54.09 EUR
042038132100000	M10	1,5	6H	100	15	10	8	57.00 EUR	68.97 EUR

Use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content $< 10\%$	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	15-20	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content $< 10\%$	blind hole (thread length $L < 2,5d_1$)	15-20	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content $< 10\%$	blind hole (thread length $L < 1,5d_1$)	15-20	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content $< 10\%$	blind hole (thread length $L < 2d_1$)	15-20	Cutting Oil/Emulsion	Possible use
Aluminium alloys si content $> 10\%$	blind hole (thread length $L < 1,5d_1$)	12-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content $> 10\%$	blind hole (thread length $L < 2d_1$)	12-15	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Aluminium alloys si content > 10%	blind hole (thread length < 1,5 d1, pilot drilling depth $\geq L+d1$)	12-15	Cutting Oil/Emulsion	Recommended use
Aluminium alloys si content > 10%	blind hole (thread length $L < 2,5d1$)	12-15	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length $L < 1,5d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length $L < 2xd1$)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth $\geq L+d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Case hardened steels and nitriding steels up to 1100 N/mm2	blind hole (thread length $L < 2,5d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (long chipping)	blind hole (thread length < 1,5 d1, pilot drilling depth $\geq L+d1$)	10-12	Cutting Oil/Emulsion	Possible use
Copper alloys (long chipping)	blind hole (thread length $L < 2,5d1$)	10-12	Cutting Oil/Emulsion	Possible use
Copper alloys (long chipping)	blind hole (thread length $L < 1,5d1$)	10-12	Cutting Oil/Emulsion	Possible use
Copper alloys (long chipping)	blind hole (thread length $L < 2xd1$)	10-12	Cutting Oil/Emulsion	Possible use
Copper alloys (short chipping)	blind hole (thread length $L < 1,5d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length $L < 2xd1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length < 1,5 d1, pilot drilling depth $\geq L+d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Copper alloys (short chipping)	blind hole (thread length $L < 2,5d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Free cutting steels up to 800 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth $\geq L+d1$)	10-12	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length $L < 2,5d1$)	10-12	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length $L < 1,5d1$)	10-12	Cutting Oil/Emulsion	Possible use
Free cutting steels up to 800 N/mm2	blind hole (thread length $L < 2xd1$)	10-12	Cutting Oil/Emulsion	Possible use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length < 1,5 d1, pilot drilling depth $\geq L+d1$)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm2	blind hole (thread length $L < 2,5d1$)	10-12	Cutting Oil/Emulsion	Recommended use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 1,5d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Heat-treated steels up to 1100 N/mm ²	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Plain cast steels up to 800 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-12	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	blind hole (thread length $L < 2,5xd_1$)	10-12	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	10-12	Cutting Oil/Emulsion	Possible use
Plain cast steels up to 800 N/mm ²	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	12-15	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2,5xd_1$)	12-15	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 1,5xd_1$)	12-15	Cutting Oil/Emulsion	Possible use
Spheroidal graphite cast iron and malleable cast iron	blind hole (thread length $L < 2xd_1$)	12-15	Cutting Oil/Emulsion	Possible use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 2,5xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 450 - 800 N/mm ²	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $< 1,5 d_1$, pilot drilling depth $\geq L+d_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Stainless steels and heat resisting steels with strength 600 - 1000 N/mm ²	blind hole (thread length $L < 2,5xd_1$)	10-12	Cutting Oil/Emulsion	Recommended use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $L < 1,5xd_1$)	10-12	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length $L < 2xd_1$)	10-12	Cutting Oil/Emulsion	Possible use

MACHINED MATERIAL	HOLE TYPE	CUTTING SPEED	LUBRICATION	USE
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length < 1,5 d ₁ , pilot drilling depth ≥ L+d ₁)	10-12	Cutting Oil/Emulsion	Possible use
Structural steels and heat-treated steels up to 800 N/mm ²	blind hole (thread length L < 2,5xd ₁)	10-12	Cutting Oil/Emulsion	Possible use
Tool steels up to 1100 N/mm ²	blind hole (thread length L < 1,5xd ₁)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length L < 2xd ₁)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length < 1,5 d ₁ , pilot drilling depth ≥ L+d ₁)	10-12	Cutting Oil/Emulsion	Recommended use
Tool steels up to 1100 N/mm ²	blind hole (thread length L < 2,5xd ₁)	10-12	Cutting Oil/Emulsion	Recommended use
Unalloyed aluminium	blind hole (thread length L < 1,5xd ₁)	15-30	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	blind hole (thread length L < 2xd ₁)	15-30	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	blind hole (thread length < 1,5 d ₁ , pilot drilling depth ≥ L+d ₁)	15-30	Cutting Oil/Emulsion	Possible use
Unalloyed aluminium	blind hole (thread length L < 2,5xd ₁)	15-30	Cutting Oil/Emulsion	Possible use
Unalloyed copper	blind hole (thread length < 1,5 d ₁ , pilot drilling depth ≥ L+d ₁)	15-20	Cutting Oil/Emulsion	Possible use
Unalloyed copper	blind hole (thread length L < 2,5xd ₁)	15-20	Cutting Oil/Emulsion	Possible use
Unalloyed copper	blind hole (thread length L < 1,5xd ₁)	15-20	Cutting Oil/Emulsion	Possible use
Unalloyed copper	blind hole (thread length L < 2xd ₁)	15-20	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	blind hole (thread length L < 1,5xd ₁)	10-12	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	blind hole (thread length L < 2xd ₁)	10-12	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	blind hole (thread length < 1,5 d ₁ , pilot drilling depth ≥ L+d ₁)	10-12	Cutting Oil/Emulsion	Possible use
Zinc and zinc alloys	blind hole (thread length L < 2,5xd ₁)	10-12	Cutting Oil/Emulsion	Possible use